

What is claimed:

1. A method for the preparation of a phenolic / polyurea co-polymer elastomeric coating system comprising the reaction of two components where:

- 5 (a) one component is an isocyanate quasi-prepolymer of an isocyanate and an active hydrogen containing material; and
- (b) the other component is a blend of:
- amine-terminated polyether resins,
- amine-terminated chain extenders, and
- 10 phenolic resins.

2. The phenolic / polyurea co-polymer elastomer system of Claim 1 wherein the isocyanate quasi-prepolymer is prepared from an active hydrogen containing polyether polyol and/or a phenolic resin.

15 3. The phenolic / polyurea co-polymer elastomer system of Claim 1 wherein the isocyanate quasi-prepolymer is based on an isocyanate selected from the group of isocyanates consisting of aromatic isocyanates.

20 4. The phenolic / polyurea co-polymer elastomer system of Claim 1 wherein the isocyanate quasi-prepolymer is based on an isocyanate selected from the group of isocyanates consisting of aliphatic isocyanates.

25 5. The phenolic / polyurea co-polymer elastomer system of Claim 1 wherein the amine-terminated resin is an amine-terminated polyoxyalkylene polyol or blend of amine-terminated polyoxyalkylene polyols.

30 6. The phenolic / polyurea co-polymer elastomer system of Claim 1 wherein the amine-terminated chain extender is selected from the group consisting of an aliphatic, cycloaliphatic or aromatic diamine chain extenders.

7. The phenolic / polyurea co-polymer elastomer system of Claim 1 wherein the amine-terminated chain extender is a blend of aliphatic, cycloaliphatic and / or aromatic diamine chain extenders.

8. The phenolic / polyurea co-polymer elastomer system of Claim 1 wherein the isocyanate quasi-prepolymer further contains an epoxy resin.

9. A method for the preparation of a phenolic/polyurea co-polymer elastomeric coating system comprising the reaction of two components wherein:

- (a) the first component comprises an isocyanate; and
- (b) the second component comprises a blend of:
active amine hydrogen containing materials, and
phenolic resins.

10. The method of claim 9 wherein said isocyanate comprises an isocyanate quasi-prepolymer of an isocyanate, and an active hydrogen containing material.

11. The method of claim 10 wherein said quasi-prepolymer is prepared from an active hydrogen containing material selected from the group consisting of polyols, amine-terminated alkylenes, phenolic resins, and blends thereof.

12. The method of claim 11 wherein said quasi-prepolymer is prepared from an active hydrogen containing material selected from the group consisting of polyether polyols, polyester polyols, polyesters of hydroxyl-terminated rubbers, and blends thereof, having an equivalent weight of at least about 500.

13. The method of claim 12 wherein said quasi-prepolymer is prepared from a polyether polyol based on a trihydric initiator with a molecular weight of at least about 4000.

14. The method of claim 9 wherein said phenolic resins have an active hydrogen content equal to or greater than 2.

15. The method of claim 9 wherein at least about 70 percent of the active hydrogen groups in the reaction mixture are in the form of amine groups.

16. The method of claim 10 wherein the isocyanate quasi-prepolymer is based on an isocyanate selected from the group consisting of aromatic isocyanates.

17. The method of claim 16 wherein said isocyanate quasi-prepolymer is based on the group consisting of aromatic polyisocyanates.

18. The method of claim 17 wherein the isocyanate quasi-prepolymer is based on methylene bis(4-phenylisocyanate).

19. The method of claim 10 wherein the isocyanate quasi-prepolymer is based on an isocyanate selected from the group consisting of aliphatic isocyanates.

20. The method of claim 19 wherein the isocyanate quasi-prepolymer is selected from the group consisting of aliphatic diisocyanates.

21. The method of claim 9 wherein the isocyanate index is in the range of about 0.95:1 to about 2.00:1.

22. The method of claim 9 wherein the isocyanate index is in the range of about 1.00:1 to about 1.50:1.

23. The method of claim 9 wherein the first component further comprises an epoxy resin.

24. The method of claim 9 wherein said active amine hydrogen containing materials are selected from the group consisting essentially of amine-terminated alkylenes, simple alkyl amines, amine terminated polyols, and blends thereof.

25. The method of claim 24 wherein said active amine hydrogen containing materials are selected from the group consisting of aminated diols, triols, and blends thereof, having a molecular weight greater than about 1500 and a functionality from about 2 to about 6, and an amine equivalent weight from about 750 to about 4000.

26. The method of claim 24 wherein said active amine hydrogen containing materials are a blend of primary and secondary amine-terminated polyols, having an average molecular weight of at least about 2000 and a functionality of about 2 to about 3, an amine equivalent weight from about 750 to about 4000, and greater than about 90 percent of active hydrogens in the form of amine hydrogens.

27. The method of claim 9 wherein said second component further comprises an amine-terminated chain extender selected from the group consisting of aliphatic, cycloaliphatic, and aromatic diamine chain extenders, and blends thereof.

28. The method of claim 27 wherein said amine terminated chain extenders are selected from the group consisting of 1-methyl-3,5-diethyl-2,4-diaminobenzene, 1-methyl-3,5-diethyl-2,6-diaminobenzene, and blends thereof.

29. The method of claim 28 wherein said amine terminated chain extender is 1-methyl-3,5-diethyl-2,4-diaminobenzene.

30. The method of claim 9 wherein said amine-terminated chain extenders are selected from the group consisting essentially of amine-terminated polyethers, amine-terminated alkylenes, simple alkyl amines, and blends thereof.

31. The method of claim 30 wherein said amine-terminated chain extenders are amine-terminated polyethers having a molecular weight of less than about 400 and a functionality of from about 2 to about 6.

5 32. The method of claim 9 wherein said second component further comprises hydroxyl-terminated polyether chain extenders having a functionality of from about 2 to about 6.

10 33. The method of claim 9 wherein said reaction of two components takes place in the absence of catalyst.

34. A phenolic/polyurea co-polymer composition prepared by a process comprising the steps of:

15 (a) preparing an isocyanate quasi-prepolymer of an isocyanate and an active hydrogen containing material; and

(b) mixing said isocyanate quasi-prepolymer with a resin blend containing active amine hydrogen containing materials and phenolic resins capable of reacting with said isocyanate groups of the quasi-prepolymer composition.

20 35. The composition of claim 34 wherein said process further comprises the step of introducing an epoxy resin into said isocyanate quasi-prepolymer.

25 36. The composition of claim 34 wherein said isocyanate quasi-prepolymer is prepared from an active hydrogen containing material selected from the group consisting of polyols, amine-terminated alkylenes, phenolic resins, and blends thereof.

30 37. The composition of claim 36 wherein said quasi-prepolymer is prepared from an active hydrogen containing material selected from the group consisting of polyether polyols, polyester polyols, polyesters of hydroxyl-terminated rubbers, and blends thereof, having an equivalent weight of at least about 500.

38. The composition of claim 37 wherein said quasi-prepolymer is prepared from a polyether polyol based on a trihydric initiator with a molecular weight of at least about 4000.

39. The composition of claim 34 wherein said phenolic resins have an active hydrogen content equal to or greater than 2.

40. The composition of claim 34 wherein at least about 70 percent of the active hydrogen groups in the reaction mixture are in the form of amine groups.

41. The composition of claim 34 wherein at least about 80 percent of the active hydrogen groups in the reaction mixture are in the form of amine groups.

42. The composition of claim 34 wherein the isocyanate quasi-prepolymer is based on an isocyanate selected from the group consisting of aromatic and aliphatic isocyanates.

43. The composition of claim 42 wherein the isocyanate quasi-prepolymer is based on methylene bis(4-phenylisocyanate).

44. The composition of claim 34 wherein the amount of isocyanate is equal to or greater than the stoichiometric amount based on the active hydrogen ingredients in the formulation.

45. The composition of claim 34 wherein said active amine hydrogen containing materials are selected from the group consisting essentially of amine-terminated alkylenes, simple alkyl amines, amine terminated polyols, and blends thereof.

46. The composition of claim 45 wherein said active amine hydrogen containing materials are selected from the group consisting of aminated diols, triols, and blends thereof, having a molecular weight greater than about 1500 and a functionality from about 2 to about 6, and an amine equivalent weight from about 750 to about 4000.

47. The composition of claim 45 wherein said active amine hydrogen containing materials are a blend of primary and secondary amine-terminated polyols, having an average molecular weight of at least about 2000 and a functionality of about 2 to about 3,
5 an amine equivalent weight from about 750 to about 4000, and greater than about 90 percent of active hydrogens in the form of amine hydrogens.

48. The composition of claim 34 wherein said second component further comprises an amine-terminated chain extender selected from the group consisting of aliphatic
10 diamines, cycloaliphatic diamines, aromatic diamines, alkylenes, polyethers, simple alkyl amines, and blends thereof.

49. The composition of claim 34 wherein said amine terminated chain extenders are selected from the group consisting of 1-methyl-3,5-diethyl-2,4-diaminobenzene, 1-
15 methyl-3,5-diethyl-2,6-diaminobenzene, and blends thereof.

50. A substrate coated with a phenolic / polyurea co-polymer coating comprising the reaction product of:

- (a) a first component that includes an isocyanate; and
- 20 (b) a second component that includes a blend of active amine hydrogen containing materials and phenolic resins.

51. The substrate of claim 50 wherein said first component further comprises an isocyanate quasi-prepolymer of an isocyanate and a hydrogen containing material.

52. The substrate of claim 51 wherein said quasi-prepolymer is prepared from an active hydrogen containing material selected from the group consisting of polyols, amine-terminated alkylenes, phenolic resins, and blends thereof.

53. The substrate of claim 52 wherein said quasi-prepolymer is prepared from a material selected from the group consisting of polyether polyols, polyester polyols,

amine-terminated polyethers, and polyesters of hydroxyl-terminated rubbers, having an equivalent weight of at least about 500, phenolic resins, and blends thereof.

54. The substrate of claim 53 wherein said quasi-prepolymer is prepared from a polyether polyol based on a trihydric initiator with a molecular weight of at least about 4000.

55. The substrate of claim 51 wherein the isocyanate quasi-prepolymer is based on an isocyanate selected from the group consisting of aromatic and aliphatic isocyanates.

56. The substrate of claim 51 wherein the isocyanate quasi-prepolymer is based on methylene bis(4-phenylisocyanate).

57. The substrate of claim 50 wherein said active amine hydrogen containing materials are selected from the group consisting of amine-terminated alkylenes, simple alkyl amines, amine terminated polyols, and blends thereof.

58. The substrate of claim 57 wherein said amine-terminated polyether resins are selected from the group consisting of aminated diols, triols, and blends thereof, having a molecular weight greater than about 1500 and a functionality from about 2 to about 6, and an amine equivalent weight from about 750 to about 4000.

59. The substrate of claim 58 wherein said amine-terminated polyether resins are a blend of primary and secondary amine-terminated polyols, having an average molecular weight of at least about 2000 and a functionality of about 2 to about 3, an amine equivalent weight from about 750 to about 4000, and greater than about 90 percent of active hydrogens in the form of amine hydrogens.

60. The substrate of claim 50 wherein said second component further comprises a chain extender selected from the group consisting of aliphatic diamines, cycloaliphatic

diamines, aromatic diamines, amine-terminated alkylenes, polyethers, simple alkyl amines, and blends thereof.

61. The substrate of claim 50 wherein said elastomeric coating is applied using high temperature, high pressure, plural component spray equipment that combines said first component and said second component, wherein:

said first component and said second component are impingement mixed directly in the high-pressure spray equipment, then applied to the desired substrate via said spray equipment.

62. The substrate of claim 50 wherein pigment and reinforcing materials are added to said elastomeric coating.